



# STEELON STABLE

## MILD STEEL ELECTRODE

**CLASSIFICATION :**

**IS : 814-2004 : ER 4114**  
**AWS/A 5.1 : E 6012**

**APPROVALS :**

BIS, TCE

**CHARACTERISTICS :**

A thin coated rutile type electrode designed for welding of mild steels in all conventional positions. Very stable arc, easy slag detachability and sound weld deposit are the salient features. Mechanical properties are consistently good.

**APPLICATIONS :**

- \* Structural & Construction work
- \* Tanks & barges
- \* Repairs of mild steel work
- \* Steel furniture etc.

**RECOMMENDATIONS :** Keep the electrodes dry. It is always better to redry the electrodes at 100°C for 30 minutes to obtain the best results. Use the welding current within the recommended range.

**CHEMICAL ANALYSIS**

OF WELD-METAL(%) :	C	Mn	Si	S	P
	0.10max	0.35-0.55	0.30max	0.03max	0.03max

**MECHANICAL PROP-  
ERTIES OF ALL WELD-  
METAL (AS PER  
IS : 814-2004) :**

Yield Strength	Ultimate Tensile Strength	Elongation (GL=5d)	Reduction in Area	CVN Impact Values (min) 27°C
Kg/mm <sup>2</sup>	Kg/mm <sup>2</sup>	(%)	(%)	Joules
42-46	46-56	26-28	50-65	70
N/mm <sup>2</sup>	N/mm <sup>2</sup>			Kgf.m.
410-450	450-550			7

**CURRENT CONDITIONS : USE AC OR DC (±)**

Size (mm)	2.5x350	3.15x350	4.0x450	5.0x450	6.3x450
Amps	60-90	90-120	140-180	180-220	220-260

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